

*Manufacture of 100 ton Guns*  
A S S E M B L Y

#2546- *The making*

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(OFFICIAL)

APRIL 11, 1917.

MAY -8 1917

SUBTITLE:-These pictures were taken, by special permission, at the United States Arsenal at Watervliet, N.Y.

SCENE 1- EX---PANORAMA OF BUILDINGS AND ARSENAL---#5

SUBTITLE:-Modern wars are won by men in overalls - the men who forge the terrific guns that smash a hostile fleet at twenty miles.

*men?*  
SUBTITLE:-These grimy, unknown men, who work with gigantic steam hammers that can knead steel like dough, and with delicate calipers that can measure fractions of a hair's breath, hold in their hands the defense of the nation and the lives of its defenders.

SUBTITLE:-To make a fourteen-inch gun, they begin by rough-turning a plain tube of steel.

SCENE 2- IN---CLOSE VIEW OF GUN TURNING---BEING SHAVED---#4

SUBTITLE:-Then they make hoops to go around the tube. These hoops, different in thickness, make the gun tapered.

SCENE 3- IN---PANORAMIC VIEW OF TUBE-----#4

SUBTITLE:-Boring a hoop for twelve-inch mortar.

SCENE 4- IN---MEN AT MACHINE --BORING A HOOP---#4

SUBTITLE:-This hoop, for a four-inch rifle, is heated white-hot and then slipped over the tube.

SCENE 5- IN---TUBE BEING SLIPPED OVER ROD----#4

SUBTITLE:-A water spray makes the jacket contract.

SCENE 6- IN---WATER SPRAYING ON TUBE----#4

SUBTITLE:-Forging a part of a big gun.

SCENE 7- IN---MACHINES---FORGING PART OF BIG GUN---#6

SCENE 8- IN---MACHINE HAMMERING PART OF GUN---#4

SUBTITLE:-Sixteen tons of wire - enough to reach from New York to Delaware - are wound around the gun at a tension of 50,000 pounds to the square inch.

SCENE 9- IN---MAN WINDING WIRE AROUND GUN---#4

SUBTITLE:-So great is the pressure of the wire that it actually makes the bore three thousandths of an inch smaller!

SCENE 10- IN---CLOSE VIEW OF MAN WINDING WIRE AROUND GUN---#4



SUBTITLE:-Turning the trunnion, or pivot, of a fourteen-inch gun. This trunnion supports the gun and takes the recoil.

SCENE 11- IN---CLOSE VIEW OF TRUNNION TURNING---#4

SCENE 12- IN---CLOSE VIEW OF MACHINE SHAVING TRUNNION---#4

SUBTITLE:-Boring the powder chamber.

SCENE 13- IN---CLOSE VIEW OF MAN AND MACHINE---#4

SUBTITLE:-The bore is measured frequently.

SCENE 14- IN--MEN MEASURING BORE OF GUN---#4

SUBTITLE:-Threading the breech block.

SCENE 15- IN --CLOSE VIEW OF MACHINE THREADING BREECH BLOCK---#4

SCENE 16- CLOSE VIEW OF BREECH BLOCK---TURNING---#4

SCENE 17- IN---GUN ON MACHINERY---#4

SUBTITLE:-A single wheel opens the breech.

SCENE 18- IN---MAN TURNING WHEEL --OPENS BREECH---#4

SUBTITLE:-Looking through a sixteen-inch gun.

SCENE 19- CLOSE VIEW OF INSIDE OF GUN---#4

SUBTITLE:-This modern Hammer of Thor weighs 130 tons. It hurls 2,400 pounds of steel twenty miles.

SCENE 20- IN---CLOSE VIEW OF MAN CRAWLING THROUGH GUN---#4

SUBTITLE:-In action!

SCENE 21- EX---GUN FIRING-----(THIS SCENE WILL FOLLOW LATER WITH COLOR)

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